

Date: Thursday, 12/13/2007 3:55:28 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 36277	
Estimate Number : 11081	
P.O. Number :	Part Number : D30011
This Issue : 12/13/2007 S.O. No. :	Drawing Number : D3001 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/12/2007 Type : MACHINED PARTS	Drawing Revision : B
Previous Run :	Material :
Written By : <u>J. A. 07-12-13</u>	Due Date : 12/21/2007 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est A 01.03.22 New Issue EC	
Est. rev.B added scuffing NCR 061 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.7437 sf(s)/Unit Total: 14.8743 sf(s)
 5052-H32 .040 Sheet
 Material: 5052-H32 0.040" sheet
 Batch: 104921 B 07-12-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D 3001
 Dwg Rev: B
 Prog Rev: B

B 07-12-13

2-Deburr if necessary

B 07-12-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 07-12-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6 12/14 (20)

5.0	SHEAR	SHEAR
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Comment: SHEAR
 Make as per dwg D3001

N/A

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36277

Part Number: D30011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

Handwritten: 08/02/27 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: SB 08/02/27 20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: BR 08-02-27

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: CS 8/2/27 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: LU 8/2/27 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/02/27

Job Completion



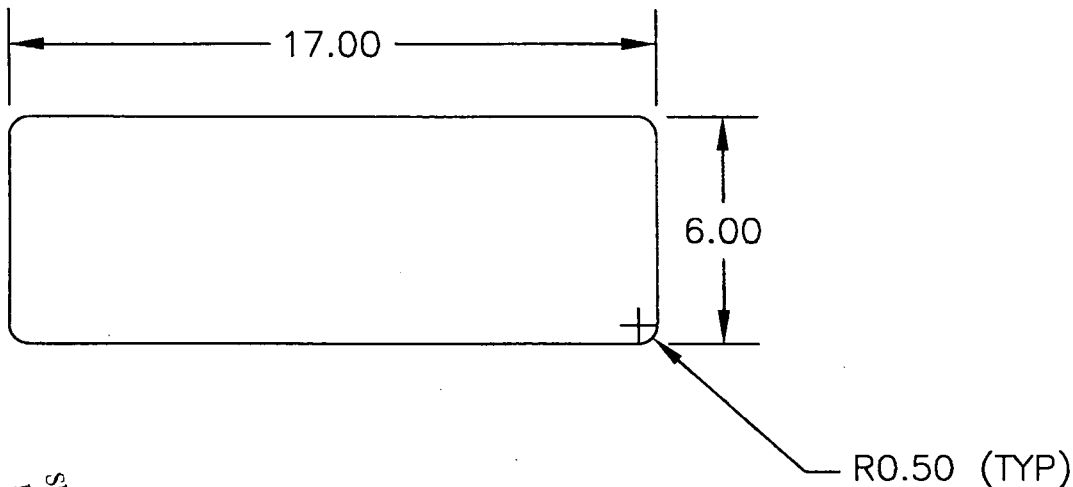
Handwritten: mi 2008/2/27 (20)

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
90	CB	DRAWING NO.	REV. B
CHECKED J. J. H.	APPROVED J. J. H.	D3001	SHEET 1 OF 1
DATE 06.10.06		TITLE DOUBLER	SCALE 1:5
A	01.03.21	NEW ISSUE	
B	06.10.06	ADD BONDING PREP NOTE	

RELEASE

06.11.03

**D3001-1 DOUBLER**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36217

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040)
OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) PREPARE FOR BONDING TO COMPOSITE STRUCTURE
PER DART QSI 006 4.10
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS TO 0.010 MAX

